

Work Order ID 54553

December 11, 2009 1:33:56 PM

HAI 06700 DEC



Page 1

Item ID: d3608-1F

Revision ID:

Item Name: Lower Doubler

Start Date: 12/14/09 Start Qty: 1.00

Required Date: 12/18/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3608

Rev A

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3608
Debur if necessary

Dwg Rev: *A*

Prog Rev: *A* 12-

12-9-17

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

12-9-17

①

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

⇒ 801217

②

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Page 2

Item ID: d3608-1F

Accept



Setup Start



Revision ID:

Item Name: Lower Doubler

Stop



Start Date: 12/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

00700DEC

9/12/11 SP @

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/12/18

MO 9-12-17

①

Picklist Print

December 11, 2009 1:33:55 PM

Work Order ID: 54553

Parent Item: d3608-1F

Parent Item Name: Lower Doubler

Comments:

Start Date: 12/14/09

Required Date: 12/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	306,3536	0.7781			



304/316 .040 Sheet



B9-12-17

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

306.3536158

110076

1.37053684

112567

38.0765789

112885

83.1578

113062

166.3723

113077

17.3764

113077

DART AEROSPACE LTD		Work Order: 54553
Description: Lower Doubler		Part Number: D3608-1
Inspection Dwg: D3608	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

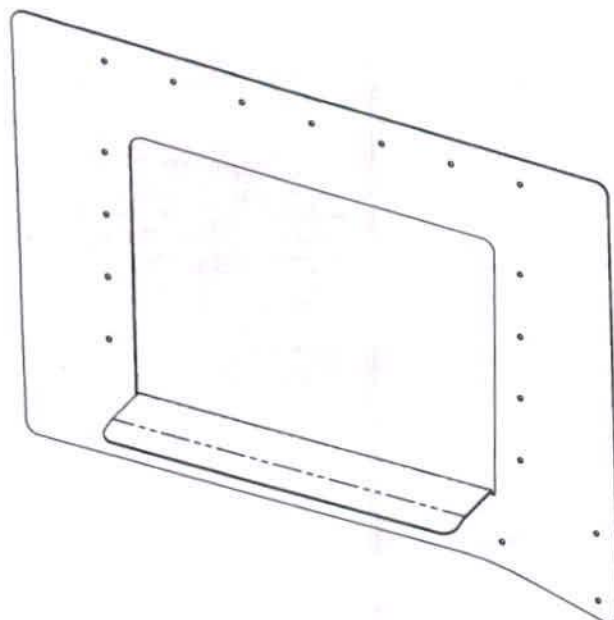
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.500	+/-0.010	.499	✓			
1.827	+/-0.010	1.821	✓			
8.100	+/-0.010	8.098	✓			
11.63	+/-0.030	11.626	✓			
0.500	+/-0.010	.499	✓			
2.25	+/-0.030	2.249	✓			
2.26	+/-0.030	2.266	✓			
1.813	+/-0.010	1.816	✓			
3.750	+/-0.010	3.745	✓			
1.25	+/-0.030	1.253	✓			
0.400	+/-0.010	.400	✓			
1.350	+/-0.010	1.350	✓			
8.90	+/-0.030	8.90	✓			
0.345	+/-0.010	.344	✓			
1.875	+/-0.010	1.874	✓			
0.423	+/-0.010	.425	✓			
6.916	+/-0.010	6.916	✓			
2.90	+/-0.030	2.909	✓			
2.179	+/-0.010	2.184	✓			
8.44	+/-0.030	8.435	✓			
1.344	+/-0.010	1.344	✓			
6.854	+/-0.010	6.852	✓			

Measured by: B
Date: 9-12-17

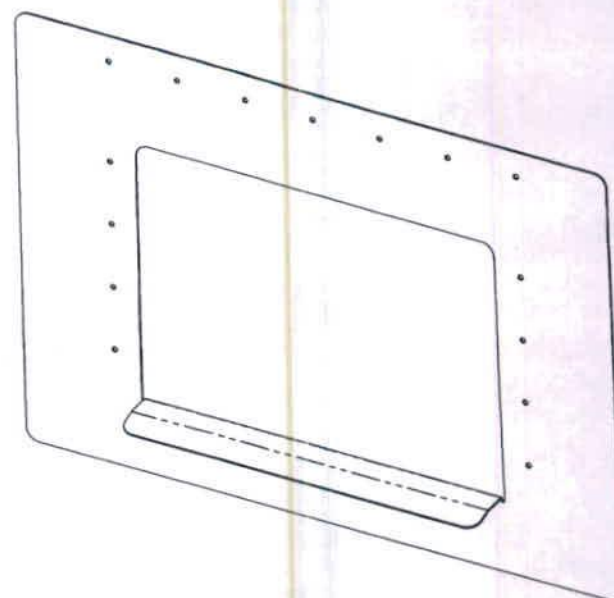
Audited by: S
Date: 09/12/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

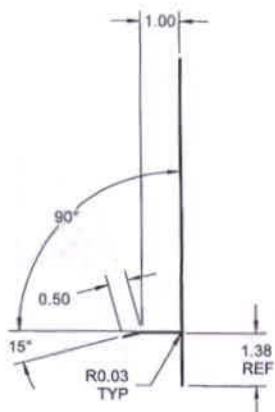
WLG 5/5/53

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08/12/10

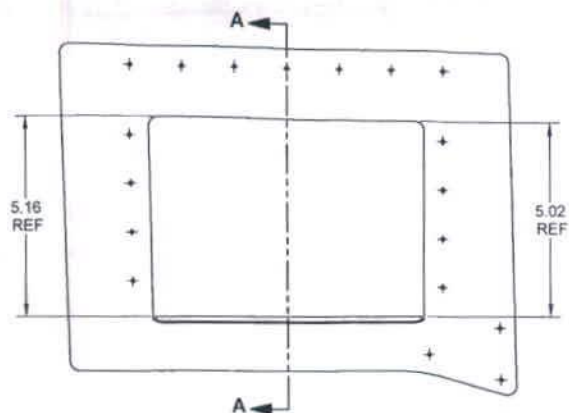
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs EACH

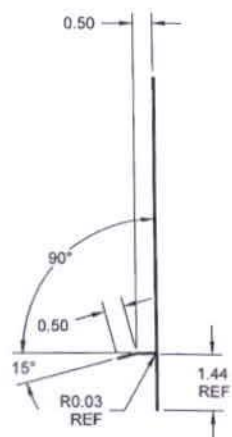
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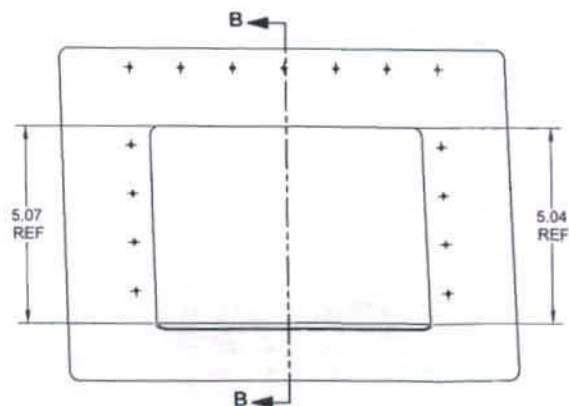
SECTION A-A



D3608-1 LOWER DOUBLER
(MAKE FROM D3608-1F)



SECTION B-B

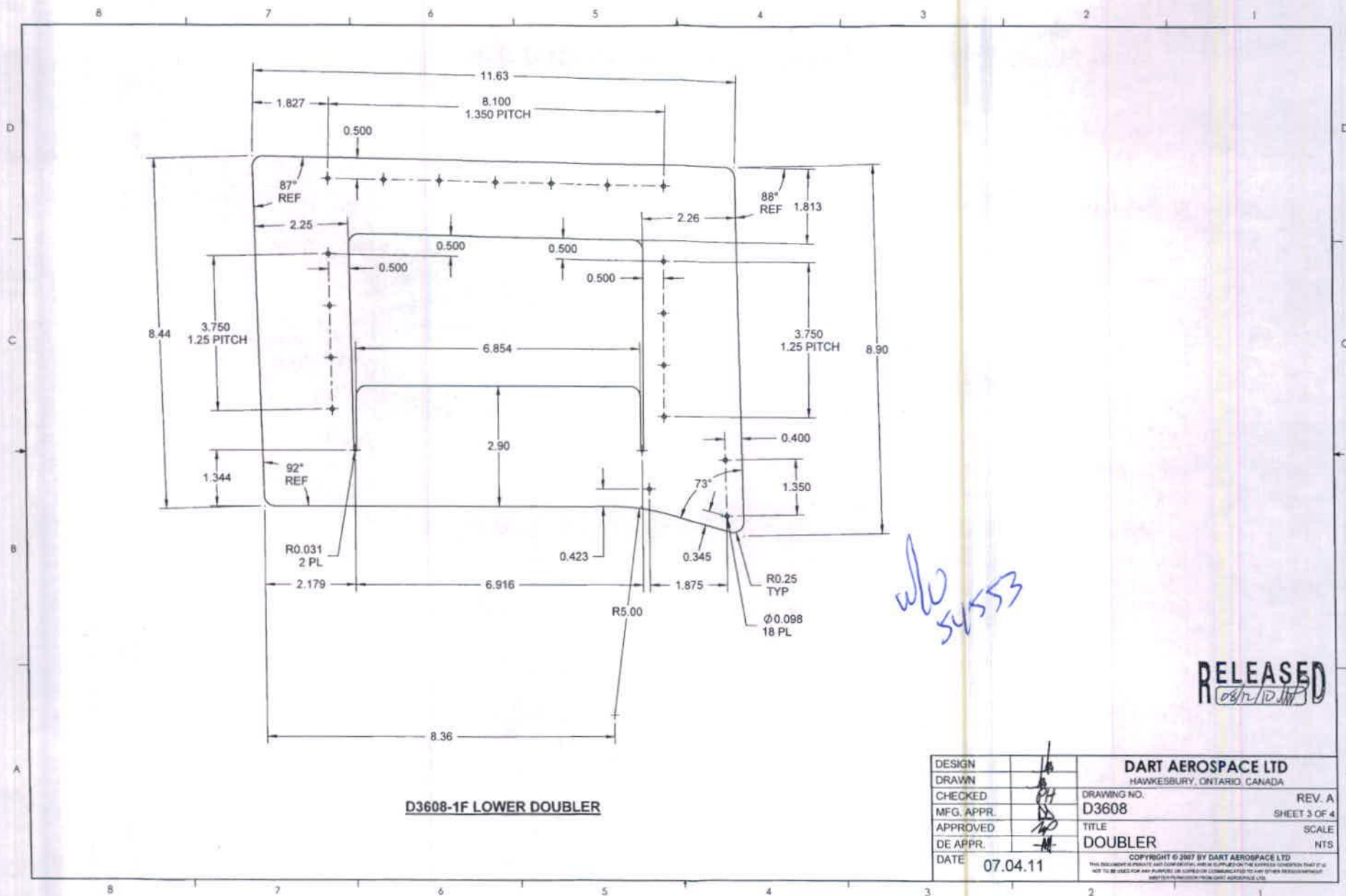


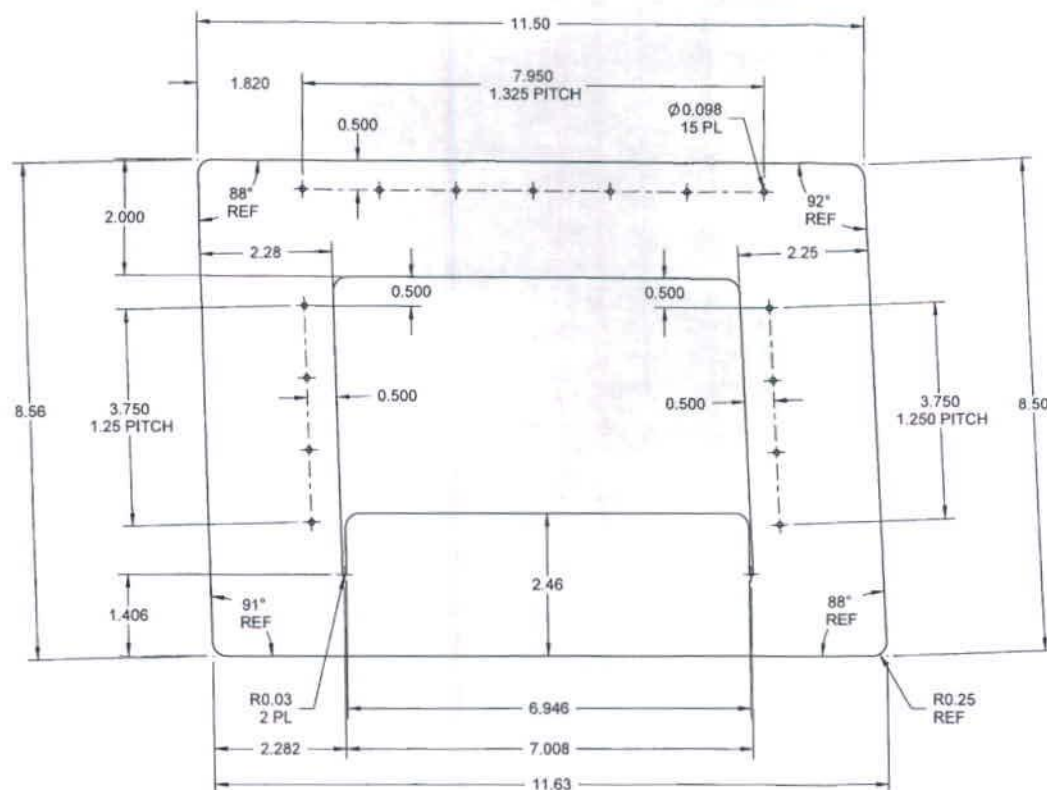
D3608-3 UPPER DOUBLER
(MAKE FROM D3608-3F)

54553

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08/12/2011

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D3608-3F UPPER DOUBLER

W10 54553

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